

Date: Wednesday, 2/15/2006 3:46:04 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 25829	
Estimate Number : 10530	
P.O. Number : <del>NA</del>	Part Number : D2571
This Issue : 2/15/2006 S.O. No. : <del>N/A</del>	Drawing Number : D2571 REV <del>DE</del>
Prsht Rev. : NC	Project Number : <del>N/A</del>
First Issue : <del>NA</del> Type : MACHINED PARTS	Drawing Revision : <del>DE</del> <i>UP 06.02.16</i>
Previous Run : 25828	Material : <del>N/A</del>
Written By : <i>See Comment Below</i>	Due Date : 3/15/2006 Qty: 10 Um: Each
Checked & Approved By : <i>06.02.16</i>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
7075-T7351 8.25X7.75X2.5  
Make from D6101-007 billet for D2571  
Ensure that grain is along 7.75" length  
Batch No: B24070

*BG FOR EO / S.G. 06/02/21 10*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 25829 Double check by: BG

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

*BG FOR EO / S.G. 06/02/21 10*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

*BG FOR EO / S.G. 06/02/25 10*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*BG FOR EO / S.G. 06/02/25 10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 10/03/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25829

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

36

06.02.27

10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-03-01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MA

06 03 06

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 31478

C 206103107

10

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/08

Job Completion



UL 06-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25829</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.747	1.746		
C	3.495	3.505		3.495	3.496	3.498	3.497		
D	1.745	1.755		1.746	1.746	1.747	1.746		
E	7.990	8.010		8.008	8.006	8.005	8.005		
F	0.490	0.510		0.494	0.504	0.503	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.498	0.499	0.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.563	0.565	0.564		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.494	1.493	1.493	1.493		
N	2.495	2.505		2.497	2.495	2.499	2.497		
O	3.869	3.879		3.871	3.870	3.872	3.872		
P	0.115	0.135		0.122	0.125	0.128	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.246	0.249	0.244	0.244		
S	0.115	0.135		0.122	0.125	0.126	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.239	0.236	0.235		
W	0.115	0.135		0.120	0.123	0.122	0.123		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.766		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.630	0.629	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.240	0.245		
AE	1.375	1.395		1.389	1.391	1.390	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.245	0.248	0.248		
AI	2.000	2.020		2.003	2.002	2.004	2.003		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP
Date:	06/02/23

Audited by:	gm
Date:	06/02/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25829</b>
<b>Description: Saddle, Fwd Outboard</b>	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg: D2571 Rev. E</b>		<b>Page 1 of 1</b>

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B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.497	3.499	3.499	3.499		
D	1.745	1.755		1.746	1.747	1.747	1.747		
E	7.990	8.010		8.003	8.005	8.003	8.003		
F	0.490	0.510		0.499	0.496	0.499	0.499		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.177	1.175	1.174	1.174		
K	0.558	0.578		0.566	0.566	0.568	0.568		
L	1.174	1.184		1.177	1.175	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.497	2.497	2.497	2.498		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		0.121	0.122	0.124	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.248	0.247	0.248	0.244		
S	0.115	0.135		0.129	0.123	0.128	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.233	0.234	0.234		
W	0.115	0.135		0.124	0.122	0.127	0.127		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.677	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.242	0.242	0.243		
AE	1.375	1.395		1.385	1.390	1.387	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.243	0.244	0.245		
AI	2.000	2.020		2.000	2.004	2.002	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J. G
Date:	06/02/25

Audited by:	BC
Date:	06.02.27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.495	0.499				
J	1.174	1.184		1.174	1.177				
K	0.558	0.578		0.568	0.568				
L	1.174	1.184		1.177	1.177				
M	1.490	1.500		1.494	1.494				
N	2.495	2.505		2.499	2.498				
O	3.869	3.879		3.873	3.870				
P	0.115	0.135		0.125	0.125				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.250	0.245				
S	0.115	0.135		0.125	0.125				
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Z	0.352	0.372		0.360	0.366				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.627	0.628				
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AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.250	0.250				
AH	0.240	0.260		0.250	0.250				
AI	2.000	2.020		2.008	2.008				
AJ	0.023	0.043		0.030	0.030				
Accept/Reject									

Measured by:	J. G.
Date:	06/02/25

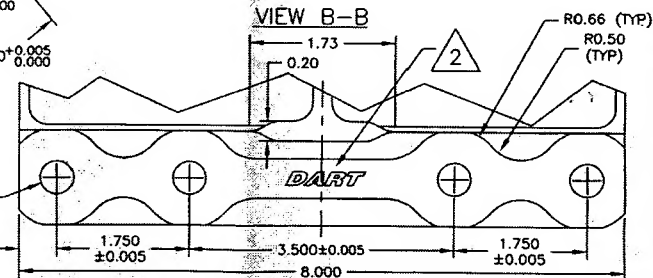
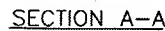
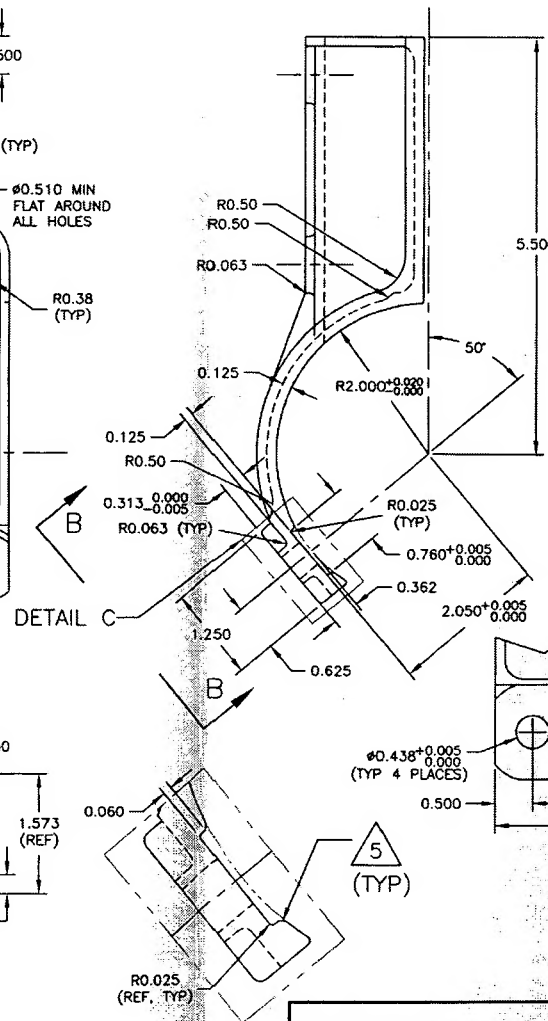
Audited by:	386
Date:	06.02.27


Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER: COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE

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SHOP COPY  
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WITHOUT  
AMENDMENT  
WORK ORDER  
NO. 25829